

Work Order ID 144814

144814

Page 1

Monday, April 25, 2016 1:39:33 PM

Item ID: D4771-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate
 Start Date: 4/25/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 4/28/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: dm WW Date: 16/04/25 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4771	C								
100		0.00							
100									
Waterjet	Memo	1.76							
FLOW CNC Waterjet	1-Cut as per dwg prog rev: <u>C</u> dwg rev: <u>C</u>								
	2-Deburr if required								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.04							
Quality Control									

⑦

16/05/05

⑦

16/05/05

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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144814

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N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

4

Cust Item ID:

4

Customer:

Reference:

Run Start *NR1*

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

**Insp.
Stamp**

120

OC

Memo

0.08

Quality Control

DAS
38
9-89
MAY 05 2016

130

0.00

130

Small Fab

Memo

0.20

Small Fab

Form as per dwg D4771

**DAS
30
9-89**

MAY 10 2016

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.08

Quality Control

DAS
38
9-89

MAY 11 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Work Order ID 144814

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144814

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Item ID: D4771-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate
Start Date: 4/25/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 4/28/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>W/A</u>	0.00				<u>7</u>	<u>12</u>	<u>16-5-16</u>	
150									
Packaging	Memo	0.04							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.40							
Quality Control									

ML5 MAY 17 2016

ML5 MAY 16 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : ☐					

Picklist Print

Monday, April 25, 2016 1:39:45 PM

Page 1
1

Work Order ID: 144814

144814

Parent Item: D4771-1

D4771-1

Parent Item Name: Wearplate

Start Date: 4/25/2016

Required Date: 4/28/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 13.03.27 NEW ISSUE DD VERF:JLM IPP
REV:B 13.11.13 DWG REV.B DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased		No			sf	387.4482		13.13684			

M304S18GA

304/316 .050 Sheet

alle 05/05

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	166.096	
M133328	112.496	
M133587	53.6	
MAT20	128	
M134580	128	
TPI	93.3522	
M134604	93.3522	

17

DQA: _____ Date: _____



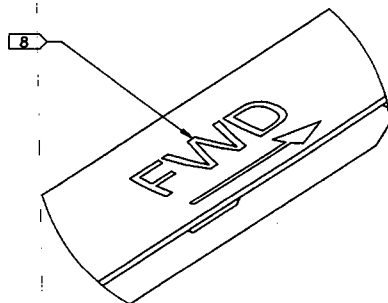
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

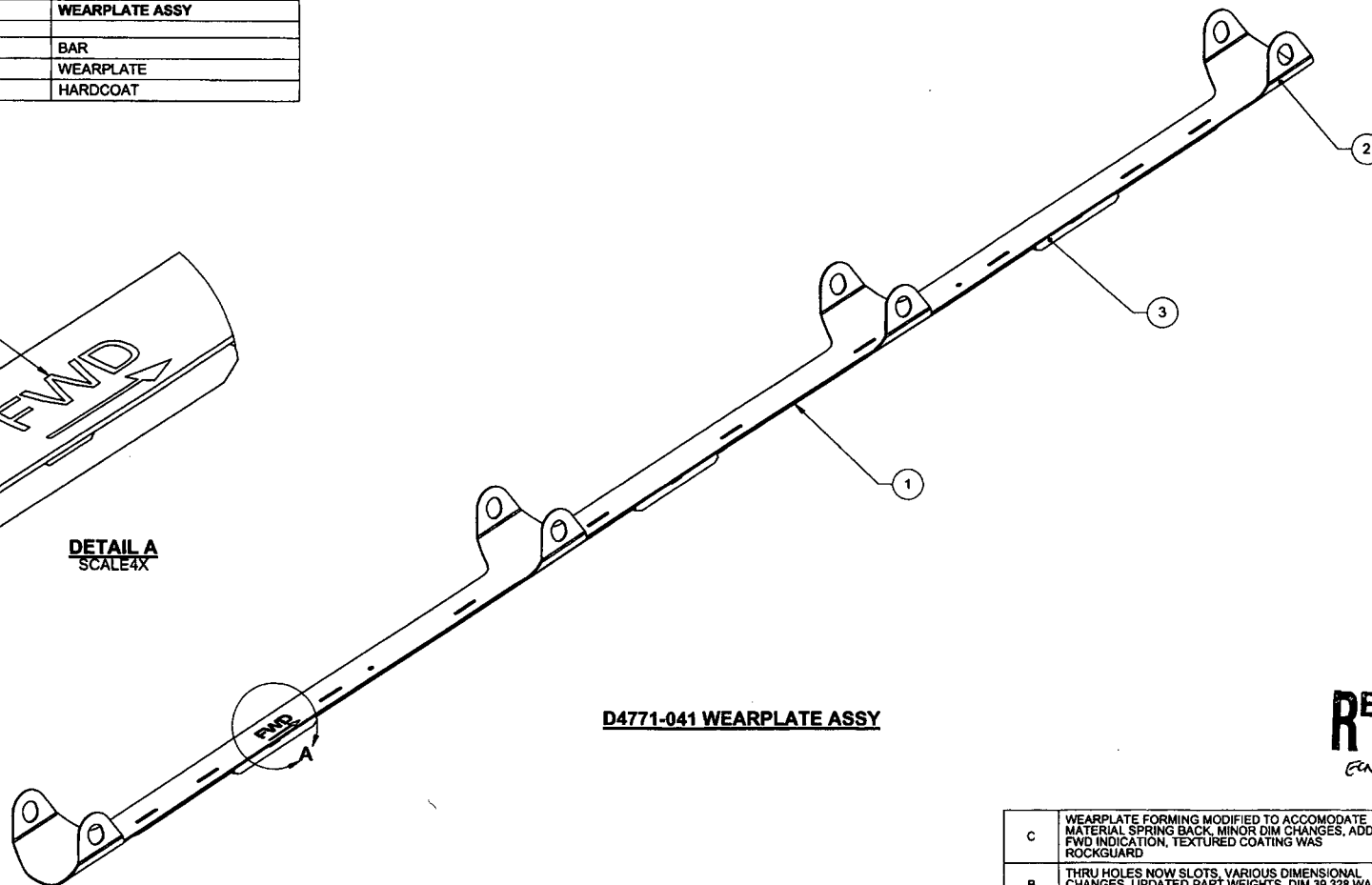
Work Order update only ☐

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OTHER : _____					

ITEM	QTY	P/N	DESCRIPTION
	X	D4771-041	WEARPLATE ASSY
1	1	D4770-5	BAR
2	1	D4771-1	WEARPLATE
3	A/R	2059B	HARDCOAT



DETAIL A
SCALE 4X



D4771-041 WEARPLATE ASSY

RELEASED
2015-06-08
ECN 15-551

NOTES:

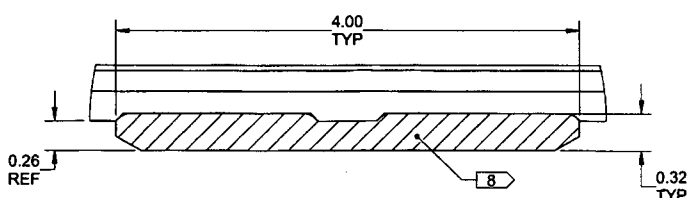
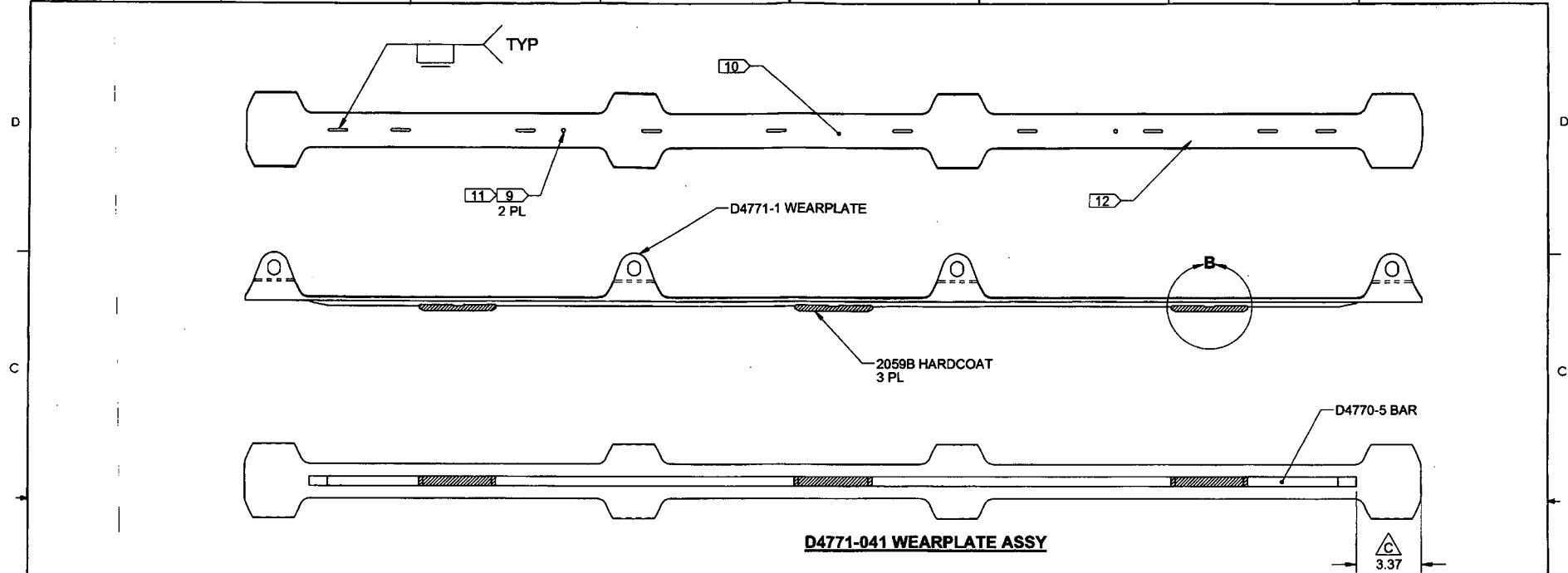
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 METHOD 6.1
- 7) WEIGHT: 4.50 lbs
- 8) INDICATE FWD DIRECTION IN LOCATION SHOWN USING WHITE PAINT MARKER

C	WEARPLATE FORMING MODIFIED TO ACCOMMODATE MATERIAL SPRING BACK, MINOR DIM CHANGES, ADDED FWD INDICATION, TEXTURED COATING WAS ROCKGUARD	AP	15.04.01
B	THRU HOLES NOW SLOTS, VARIOUS DIMENSIONAL CHANGES, UPDATED PART WEIGHTS, DIM 39.328 WAS 41.876 (CS-3)	AP	13.08.08
A	NEW ISSUE	AP	13.02.13
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO.	REV. C
MFG. APPR.	DD	D4771	SHEET 1 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
DATE	15.04.01	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

APPROVED

w/o 144814 — Rm 16/04/25

18 7 6 5 4 3 2 1



DETAIL B
SCALE 6X
3 PL

RELEASED
2015-06-08

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 METHOD 6.1
- 7) WEIGHT: 4.50 lbs
- 8) WELDING: PER QSI 004, 2059B HARDCOAT WELD, 0.32 THICK x 0.50 WIDE, FLUSH WITH D4770-5 BAR ON LATERAL SURFACES, 3 PL
- 9) TRANSFER DRILL $\phi 0.188$ HOLES FROM D4771-1 WEARPLATE TO D4770-5 BAR
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF TEXTURED COATING, 0.020-0.040 THICK, PER QSI 005 SECTION 4.9
- 11) OPEN UP DRAIN HOLE IF NECESSARY TO $\phi 0.188$ AFTER APPLYING TEXTURED COATING

APPROVED

DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO.	REV. C
MFG. APPR.	DD	D4771	SHEET 2 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
DATE	15.04.01	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

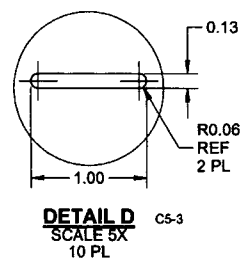
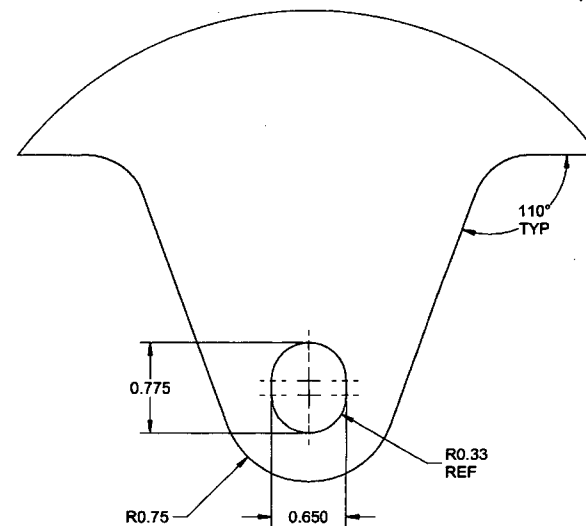
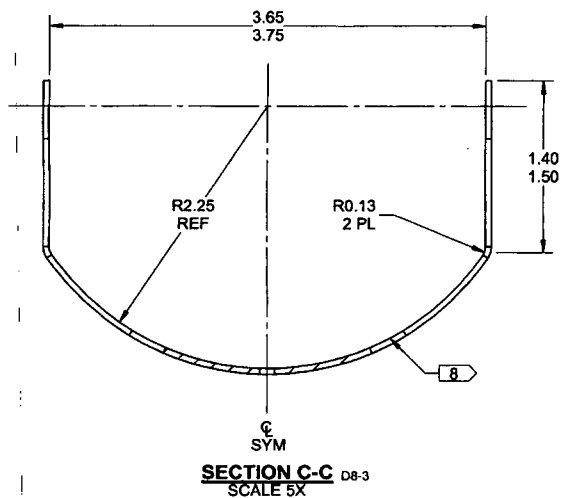
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